

3M

Polyurethane Adhesive

6316/6316B

Technical Data

May, 2016

Product Description 6316/6316B is 100% solid content, one part and moisture cured polyurethane adhesive. It features low viscosity, easy to work and great bonding performance to glass, plastics and metal.

- Specific Features**
- Low viscosity, easy to operate
 - Fast initial strength
 - Longer open time
 - Suitable for 0.5mm bonding width
 - Great waterproof and airtight property

Physical Properties

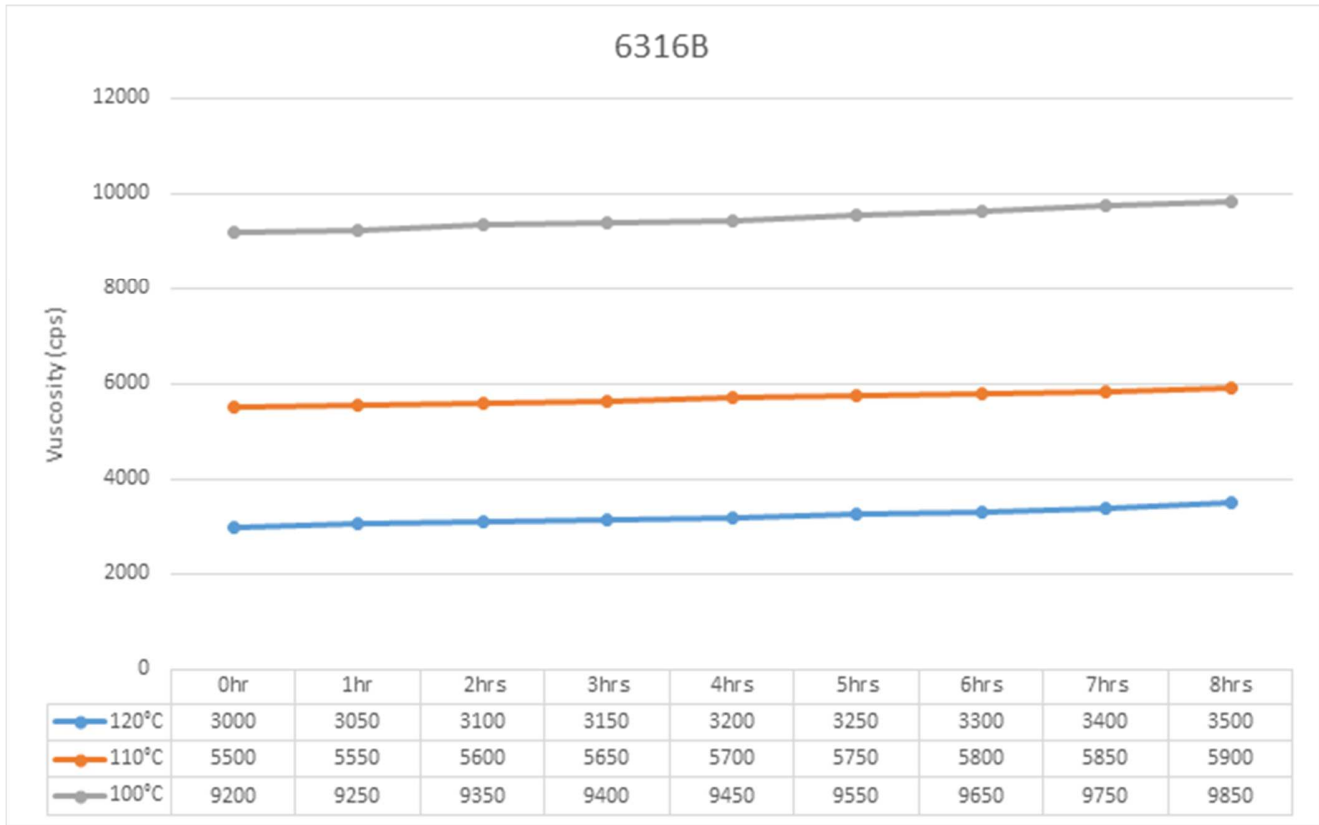
Note: The data are measured by 3M internal lab test method and environment, cannot act as product spec.

Polyurethane Adhesive 6316/6316B	
Base	PU
Solid Content(%)	100%
Appearance	Off-white/Black
Viscosity(cps)	3,000cps (120°C)
Open Time	3mins ~4mins
Hardness	Around 75 (Shore A)

Heating Temperature and Viscosity	
Temperature	Viscosity(cps)
90°C	12,000
100°C	7,500
110°C	4,500
120°C	3,000
130°C	1,500
Brookfield DV-E , #S27, 10rpm	

Viscosity Change with Heating Time

Brookfield DV-E , #S27, 10rpm



Performance

Strength build-up with time, Shear Force (Kg/cm²)

Substrate	5mins	30mins	60mins	120mins	24hrs	72hrs
PC to PC	3	5	9	16	44	46

Glue Thickness : 0.15mm

ASTM D1002-05, testing speed is 50mm/min

Strength Comparison at Various Substrate (25°C 50%RH 24hrs, Kg/cm²)

Substrate	PC to PC	PC to Al	PC to Glass	Glass to Al
Shear Force	44	37	41	23

Push Force
(25°C 50%RH 24hrs, Kgf/cm²)

Substrate	Glass to PC
Push Force	36

Instruction Please avoid to heat over 8 hours and make sure the outside environment is in open area

Safety Refer to MSDS

Storage and Shelf life 12 months at un-open under 16°C~27°C, 50%RH

3M
Industrial Adhesives and Tapes Division
3M Taiwan Ltd.,
6F., No.95, Sec. 2, Dunhua S. Rd.
Taipei 10682, Taiwan
www.3M.com/adhesives